

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017654**Date Inspected:** 29-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (10AE)

This QA inspector witnessed the final bolt tension verification on the FL3 to bottom panel of segment 10AE. The torque wrench S/N was XO2-666. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 86 to PP 88:

M24 X 60 – DHGM 240014 – 567 NM

M24 X 65 – DHGM 240013 – 540 NM

M24 X 70 – DHGM 240010 – 1 200 NM

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (10AE)

This QA inspector witnessed the final bolt tension verification on the FL3 to side panel of segment 10AE. The torque wrench S/N was XO2-666. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

bolt size designations were as follows:

PP 86 to PP 88:

M24 X 65 – DHGM 240013 – 540 NM

OBG # TRIAL ASSEMBLY YARD (10CE)

This QA inspector witnessed the final bolt tension verification on the FL3 to bottom panel of segment 10CE. The torque wrench S/N was XO2-666. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 86 to PP 88:

M24 X 60 – DHGM 240014 – 567 NM

M24 X 65 – DHGM 240013 – 540 NM

M24 X 70 – DHGM 240010 – 1 200 NM

OBG # TRIAL ASSEMBLY YARD (10CE)

This QA inspector witnessed the final bolt tension verification on the FL3 to side panel of segment 10CE. The torque wrench S/N was XO2-666. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 86 to PP 88:

M24 X 65 – DHGM 240013 – 540 NM

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (11AE-11BE)

The QA inspector observed the welding operation per the SMAW process on weld joint no. 035 in the (4G) overhead position on side panel WT stiffener piece mark no. SP699-001. The location was the complete joint penetration groove weld joining the WT stiffeners of segment 11AE and 11BE. The welder ID was 044515. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

The QA inspector observed the welding operation per the SMAW process on weld joint no. 031 in the (4G) overhead position on side panel WT stiffener piece mark no. SP714-001. The location was the complete joint penetration groove weld joining the WT stiffeners of segment 11AE and 11BE. The welder ID was 044515. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (11BW)

WELDING INSPECTION REPORT

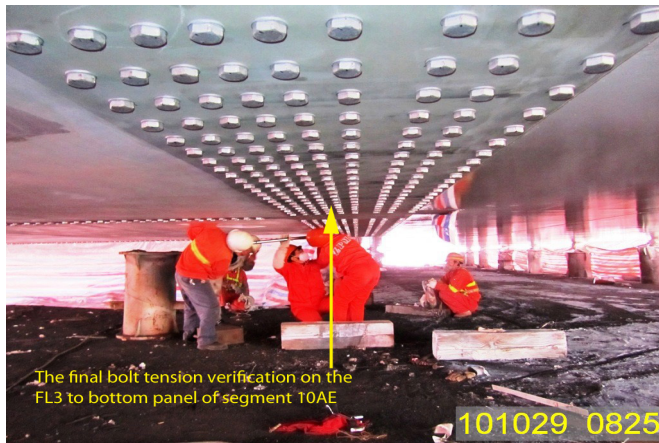
(Continued Page 3 of 3)

The QA inspector observed the welding operation per the FCAW process on weld joint no. 009 in the (4F) over head position on edge panel I stiffener piece mark no. EP120-001. The location was the hold back of I stiffener fillet weld of segment 11BW. The welder ID was 040609. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2134.

OBG # TRIAL ASSEMBLY YARD (11CW)

The QA inspector observed the welding operation per the FCAW process on weld joint no. 005 in the (4F) over head position on edge panel I stiffener piece mark no. EP121-001. The location was the hold back of I stiffener fillet weld of segment 11CW. The welder ID was 040609. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2134.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
